

Date: Monday, 30/03/2009 12:32:04 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 46722		
Estimate Number	: 11302		
P.O. Number	:	Part Number	: D34477
This Issue	: 30/03/2009 S.O. No. :	Drawing Number	: D3447 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 43926	Material	:
Written By	:	Due Date	: 06/04/2009 Qty: 16 Um: Each
Checked & Approved By	: <u>mf 09-03-30</u>		
Comment	: Est.A 05.08.26 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6R1.250

1.125

6061-T6 Round Bar 1.250



Comment: Qty.: 0.4633 f(s)/Unit Total: 7.4122 f(s)

6061-T6 Round Bar 1.250

Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8)

M6061T6R1.250

Identify for D3447-7

Batch: M1106634

1.125"

106634

mf 09/04/02

(8)

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Turn as per Folio

& Dwg B67-43001 Dwg Rev: N/A

mf 09/04/02

(8)

3.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

Turn 3.750" dimension to Ø0.975

Mill as per Dwg D3447

Deburr

N/A

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 09/04/03

(8)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

H.A 09/04/03

(8)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

CMY BR

09/04/06 *(18)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask square section

18/44
M 10/15/18

START TIME:

11:15

OVEN TEMPERATURE:

300°

FINISH TIME:

11:45

BR 09-04-7

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/08 *(8)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

742

9/4/1

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



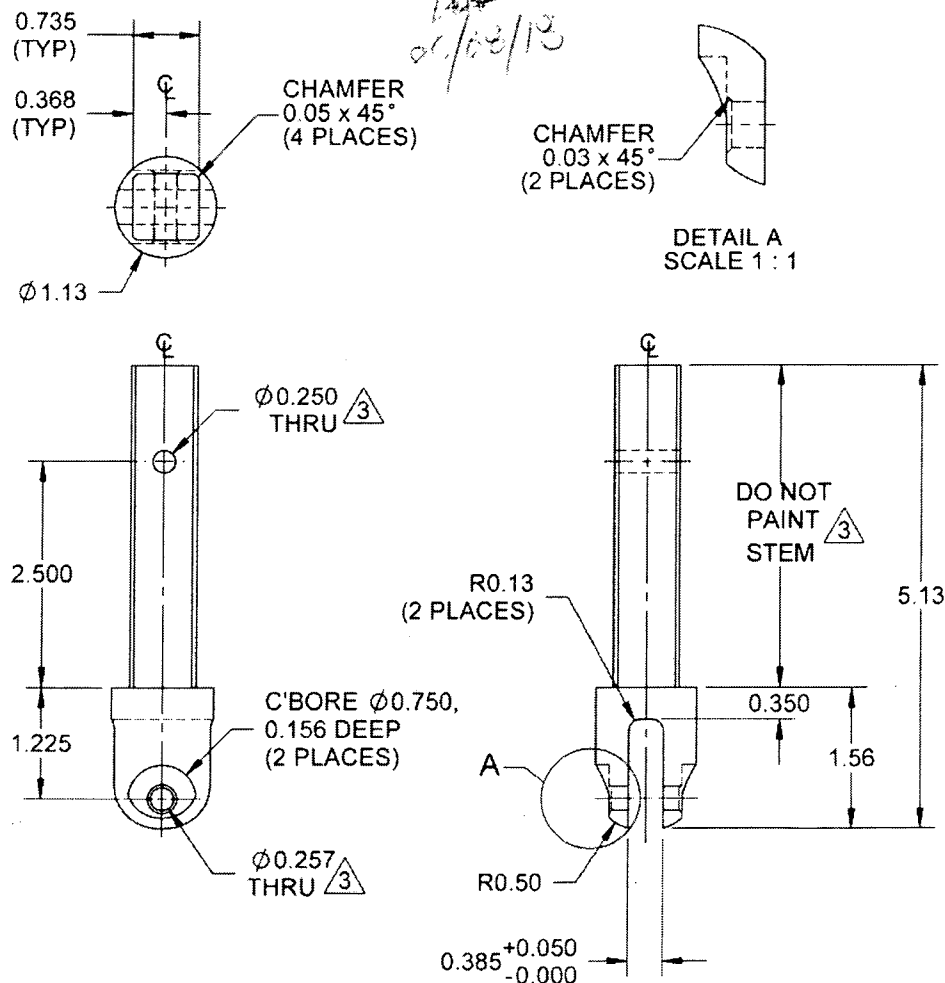
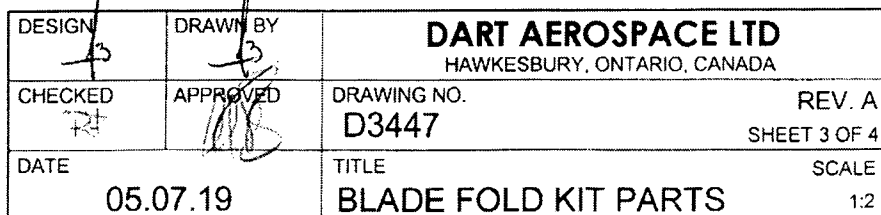
Comment: FINAL INSPECTION/W/O RELEASE

09/04/08 *(8)*

Job Completion



MF 09-04-08



46722

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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